



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.9710

Job Sheet 197808



Part No: 646.9710

Job Qty: 12 pcs

Part Name: Body



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/17/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 8/20/19

Type: Stock

Description:

Note: DWG 646.9700 REV G IPP REV A NEW ISSUE 12/10/04 JFS VERIFY BY: DD

Ship Via:

Rev H

DAS
35
9-89

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup	Run		
					Hrs	Hrs	Workcenter / Supplier Lead Time	
110	HAAS 4 Axis	12 pcs	8/20/19	0.22	6.00		HAAS - 1	DAS 52 9-89 19/08/13
							HAAS - 2	
							HAAS - 3	
							HAAS - 4	
120	QC 2	12 pcs	8/20/19	0.00	0.00		QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S205257



Part: 646.9710

Job No: 197808

Serial No/Batch: S205257

Revision: G

Inspector:

Exp Date:

Instructions: Various STC's

Date: 08/13/19

130 QC 8	12 pcs	8/20/19	0.00 0.00	QC 2 - 66		
				QC 2 - 64		
				QC 2 - 65		
				QC 2 - 5		
				QC 2 - 71		
				QC 2 - 73		
				QC 2 - 69		
				QC 8 - 12		
				QC 8 - 14		
				QC 8 - 17		
				QC 8 - 20	19-08-15	
				QC 8 - 25		
				QC 8 - 3		
				QC 8 - 32		
				QC 8 - 33		
				QC 8 - 35		
				QC 8 - 39		
				QC 8 - 4		
				QC 8 - 44		
				QC 8 - 45		
				QC 8 - 49		
				QC 8 - 58		
				QC 8 - 8		
				QC 8 - 9		
				QC 8 - 68		
				QC 8 - 67		
				QC 8 - 1 (A)		
				QC 8 - 47		
				QC 8 - 40		
				QC 8 - 52		
				QC 8 - 23		
				QC 8 - 57		
140 Outsource - 4 - Anodize	12 pcs	8/20/19		ATG001-VC	10	19-08-16
150 Packaging 2-1 - Receive - B4B	12 pcs	8/20/19	0.00 0.00	Packaging 2 - 1 - B4B		
				Packaging 2 - 2 - B4B		
				Packaging 2 - 3 - B4B		
				Packaging 2 - 5 - B4B		
				Packaging 2 - 4 - B4B		
				Packaging 2 - 6 - B4B		
				Packaging 2 - 7 - B4B		
				Packaging 2 - 8 - B4B		
				Packaging 2 - 9 - B4B		
				Packaging 2 - 10 - B4B		
				Packaging 2 - 11 - B4B		
				Packaging 2 - 12 - B4B		
				Packaging 2 - 13 - B4B	DP AUG 28 2019	
				Packaging 2 - 14 - B4B		
				Packaging 2 - 15 - B4B		
				Packaging 2 - 16 - B4B		
				Packaging 2 - 17 - B4B		
				Packaging 2 - 18 - B4B		
				Packaging 2 - 19 - B4B		
				Packaging 2 - 20 - B4B		
				Packaging 2 - 21 - B4B		
				Packaging 2 - 22 - B4B		
				Packaging 2 - 23 - B4B		
				Packaging 2 - 24 - B4B		
				Packaging 2 - 25 - B4B		
				Packaging 2 - 26 - B4B		
				Plex 7/17/19 7:47 AM Dart.lajeunesse.marie		

					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
155 QC 6	12 pcs	8/20/19	0.00 0.00		QC 6 - 9	
					QC 6 - 68	DAS
					QC 6 - 61	61
					QC 6 - 40	9-89
					QC 6 - 81	
160 Spray Paint - 2 - B4B N/R	12 pcs	8/20/19	0.00 2.00		Spray Paint - 1 - B4B	
					Spray Paint - 2 - B4B	
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
165 QC 14 N/R	12 pcs	8/20/19	0.00 0.00		QC 14 - 15	
					QC 14 - 2	
					QC 14 - 34	
					QC 14 - 41	
					QC 14 - 51	
					QC 14 - 58	
					QC 14 - 59	
					QC 14 - 9	
					QC 14 - 68	
					QC 14 - 40	
					QC 14 - 19	
					QC 14 - 43	
					QC 14 - 24	
					QC 14 - 61	
					QC 14 - 81	
180 Packaging 3-1 - Stock - B4B	12 pcs	8/20/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
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					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					QC 21 - SA - 21	DAG
					QC 21 - SA - 70	21 SEP 04 2019
190 QC 21 - SA	12 pcs	8/20/19	0.00 0.00	QC 21 - SA - 53	P-03	

Part Op 110 - (HAAS CNC Vertical Machine), 1-Machine per folio FB130
 Descriptions: 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - (Outsource process-Anodize per QSI017 4.1.10.1), Issue P/O to: 44280 Hard Black Anodize Color Black and Prime as per Dwg 646.9700
 150 - (Receive & Inspect for Damage & Mat'l Certs)
 155 - (QC6- All purchased or subcontracted products)
 160 - (Spray Paint / NDT Room)-PRIME CARDINAL 7760-4702 LOW VOC EPOXY PRIMER (LIGHT GRAY)
 165 - (QC14- Inspect Spray Paint)
 180 - (Identify as per dwg & Stock Location: _____), ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***
 190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6S1.000X5.000	7075-T6 Sheet1" Thick Plate X 5" Wide	7.4520 ft (.621 ea)	110-HAAS 4 Axis	5/5 60 73

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-HAAS 4 Axis	M7075T6S1.000X5.000	7	38	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Body	0.130Inches ± 0.010	0.140 0.120	0.120	
2	Body	45.0Angle ± 0.5	45.5 44.5	45°	
3	Body	1.500Inches ± 0.005	1.505 1.495	1.499	
4	Body	0.352Inches + 0.005 - 0.000	0.357 0.352	0.352	
5	Body	0.100Inches ± 0.010	0.110 0.090	0.105	
6	Body	45.0Angle ± 0.5	45.5 44.5	45°	
7	Body	0.875Inches ± 0.005	0.880 0.870	0.8725	
8	Body	0.700Inches ± 0.005	0.705 0.695	0.701	
9	Body	5.500Inches ± 0.005	5.505 5.495	5.500	
10	Body	0.660Inches ± 0.005	0.665 0.655	0.658	
11	Body	0.660Inches ± 0.005	0.665 0.655	0.659	
12	Body	0.278Inches ± 0.002	0.280 0.276	0.278	
13	Body	0.339Inches ± 0.002	0.341	0.339	

			0.337	
14	Body	0.352Inches ± 0.002	0.354 0.350	0.352
15	Body	0.372Inches ± 0.002	0.374 0.370	0.372
16	Body	1.067Inches ± 0.002	1.069 1.065	1.067
17	Body	2.608Inches ± 0.002	2.610 2.606	2.608
18	Body	2.750Inches ± 0.002	2.752 2.748	2.750
19	Body	2.892Inches ± 0.002	2.894 2.890	2.892
20	Body	3.348Inches ± 0.002	3.350 3.346	3.348
21	Body	3.597Inches ± 0.002	3.599 3.595	3.597
22	Body	3.847Inches ± 0.002	3.849 3.845	3.847
23	Body	0.351Inches ± 0.002	0.353 0.349	0.351
24	Body	0.544Inches ± 0.002	0.546 0.542	0.544
25	Body	2.195Inches ± 0.002	2.197 2.193	2.195
26	Body	2.304Inches ± 0.002	2.306 2.302	2.304
27	Body	2.451Inches ± 0.002	2.453 2.449	2.451
28	Body	2.639Inches ± 0.002	2.641 2.637	2.639
29	Body	3.395Inches ± 0.002	3.397 3.393	3.395
30	Body	3.495Inches ± 0.002	3.497 3.493	3.495
31	Body	4.551Inches ± 0.002	4.553 4.549	4.551
32	Body	4.595Inches ± 0.002	4.597 4.593	4.595
33	Body	4.687Inches ± 0.002	4.689 4.685	4.687
34	Body	4.734Inches ± 0.002	4.736 4.732	4.734
35	Body	6.651Inches ± 0.002	6.653 6.649	6.651
36	Body	0.201Inches + 0.005 - 0.001	0.206 0.200	0.201
37	Body	0.177Inches + 0.005 - 0.001	0.182 0.176	0.177
38	Body	7.026Inches ± 0.005	7.031 7.021	7.026
39	Body	4.245Inches ± 0.005	4.250 4.240	4.245

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19-08-11

Entered:

Date:

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



NCR No.

Route update only

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		MRB (QSI042)			
Date : _____		Sequence #: _____		QTY Affected : _____		Disposition			
Description Work Order Deviation		Completed By							
Root Cause		Lead hand / Supervisor							
QC / QA Coordinator		Fault Category							
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐	
Other/Details:		Other/Details:							



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044280



Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044280
PO Date: 8/16/19
Due Date: 8/23/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com
Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

E-MAILED
2019-08-16

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	197510	RBE350A93-3302-02-5	Extension Handle -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	8/23/19	10 pcs	0 pcs	10 pcs	\$9.92/pcs	\$99.20
2	196966	RBW109-3501-03-17-7	Pin -Issue P/O; -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	8/23/19	4 pcs	0 pcs	4 pcs	\$9.92/pcs	\$39.68
3	196962	RBW109-3501-03-7-1	Pin -Issue P/O; -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	8/23/19	4 pcs	0 pcs	4 pcs	\$9.92/pcs	\$39.68

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
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PURCHASE ORDER

POHB044280



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	197808	646.9710	Body : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1), Issue P/O to: Hard Black Anodize Color Black and Prime as per Dwg 646.9700	Firmed -	X12	8/23/19	12 pcs	0 pcs	12 pcs	\$17.48/pcs DAS 61 9-89	\$209.76 DP
5	198167	649.5310	Lower Deflector : Various STC's Outsource process- Anodize per QSI017 4.1.10.1) Outsource process-Anodize per QSI017 4.1.10.1 Issue P/O to ATG : 1- Black Anodize as per Dwg 649.5300 2- PRIME AS PER DWG, SEE NOTE #2 Certification of Conformity is required	Firmed -	X12	8/23/19	12 pcs	0 pcs	12 pcs	\$14.43/pcs	\$173.16 DP
Grand Total:										\$561.48	

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an Integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

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A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 918467

Date: 26-Aug-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
12 ea	Part: 646.9710 Body Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 25819 PO: POHB044280	Rev: D	Line: 4
12 ea	Part: 649.5310 Lower Deflector Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 25820 PO: POHB044280	Rev: C	Line: 5
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>AUG 26 2019</u> Certified Signature:  Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. Made in Canada.			

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DART AEROSPACE LTD.
AUG 27 2019
RECEIVED